

Work Order ID 140141

Thursday, December 17, 2015 3:43:12 PM

140141

Page 1

Item ID: D3372-7

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Slider Body

Start Date: 12/17/2015 Start Qty: *204.0* ***2***

Cust Item ID:

Required Date: 12/17/2015 Req'd Qty: *200* ***2***

Customer:

Reference:

Approvals: Process Plan: *MLJ* Date: **DEC 18 2015** Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3372	Rev B

100 0.00

100

BAND SAW

Bandsaw

Memo

Jeaspa Bandsaw

Cut blank: 1.500" x 1.250" x 4.435" long

110

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

HAAS CNC vertical machine #1

Machine D3372-7 as per Folio FA495 and Dwg D3372

Deburr

120

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

Quality Control

0.00

0.00

4 0 *16/01/05*

4 0 *16/01/05*

4 0 *16/01/05*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 140141

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140141

Page 3

Item ID: D3372-7 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Slider Body
Start Date: 12/17/2015 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 12/17/2015 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Small Fab	Small Fab	0.00				4	FF		JAN 12 2016
Small Fab	Memo	0.01							
	Fabricate D3372-9 using AN6-36A bolt. Cut to length, then mill slot when bolt and D3372-7 are assembled as per Dwg D3372.1 → J.C.L. 16-01-12								
170 *170* QC	QCS- Inspect part completeness to step on W/O	0.00							DAS 38 9-88
Quality Control	Memo	0.00							
180 *180* Powdercoat	Fire Red(Ref:4.3.5.10) per OSI005 4.3	0.00							
Powder Coating	Memo	0.00							
	m 129228. 12:05 START TIME: 12:05 OVEN TEMPERATURE: 320 FINISH TIME: 12:50								
						H	φ	16-01-12	DAS 34 9-88

JAN 12 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	

Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : ☐			

Work Order ID 140141***140141***

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Thursday, December 17, 2015 3:43:12 PM

Item ID: D3372-7 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Slider Body
Start Date: 12/17/2015 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 12/17/2015 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>(4)</u>			DAS 38 9-89 JAN 13 2016
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>Σ 499</u> Memo	0.00 0.00				<u>4</u>			DAS 6 9-89 JAN 15 2016
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				<u>ML5</u>			JAN 15 2016 ML5 JAN 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
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				Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
		OTHER : ☐			

Picklist Print

Thursday, December 17, 2015 3:43:11 PM

Page 1

Work Order ID: 140141

140141

Parent Item: D3372-7

D3372-7

Parent Item Name: Slider Body

Start Date: 12/17/2015

Required Date: 12/17/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP A05.01.18New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN6-36A		Purchased	No			110	Each	30.0000	1	24			
---------	--	-----------	----	--	--	-----	------	---------	---	----	--	--	--

AN6-36A

Bolt

**

Location	Loc Qty	Loc Code
over005	25	
M133577	25	
ST333	5	
M133284	5	

DAS
27
0.03
JAN 12 2016

M6061T6B1.500X01.25		Purchased	No			160	f	15.9470	0.3833	0.806947			
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0

M6061T6B1 500X01 250

**

6061-T6 Bar 1.50 x 1.25

Location	Loc Qty	Loc Code
MAT	10.45	
m133038	10.45	
MAT003	5.497	
m129167	5.497	

1.60

ml 16/01/05

DQA: _____ Date: _____



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Misidentified ☐	Past Due ☐																																																																

DART AEROSPACE LTD		Work Order: 190141
Description: Slider Body		Part Number: D3372-7
Inspection Dwg: D3372	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

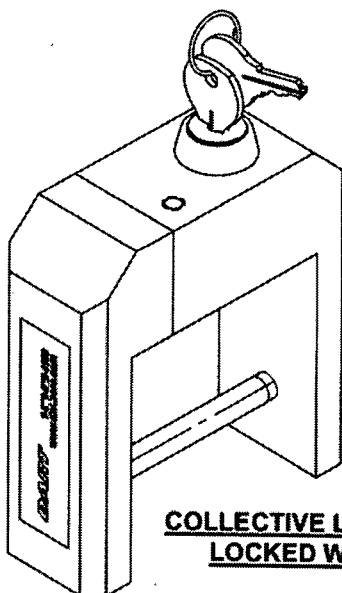
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.750	+/-0.005	0.750	✓		MJP-04	vern
0.313	+/-0.005	0.309	✓			
2.108	+/-0.010	2.108	✓			
1.50	+/-0.030	1.503	✓			
0.63	+/-0.030	0.620	✓			
4.31	+/-0.030	4.310	✓			
1.19	+/-0.030	1.190	✓			
0.613	+/-0.010	0.613	✓			
2.938	+/-0.010	2.938	✓			
1.375	+/-0.010	1.373	✓			
0.200	+/-0.010	0.200	✓			
Ø0.323	+0.005/-0.000	0.328	✓			
0.500	+/-0.010	0.500	✓			
0.881	+/-0.010	0.881	✓			
1.400	+/-0.010	1.400	✓		Caliper	JCL-08
0.398	+/-0.010	0.391	✓		"	
0.200	+0.010 -0.000	0.200	✓		"	

Measured by: [Signature]	Audited by: DAS 44	Prototype Approval:	N/A
Date: 16/01/05/18-20-02	Date: 16/01/08	Date:	N/A

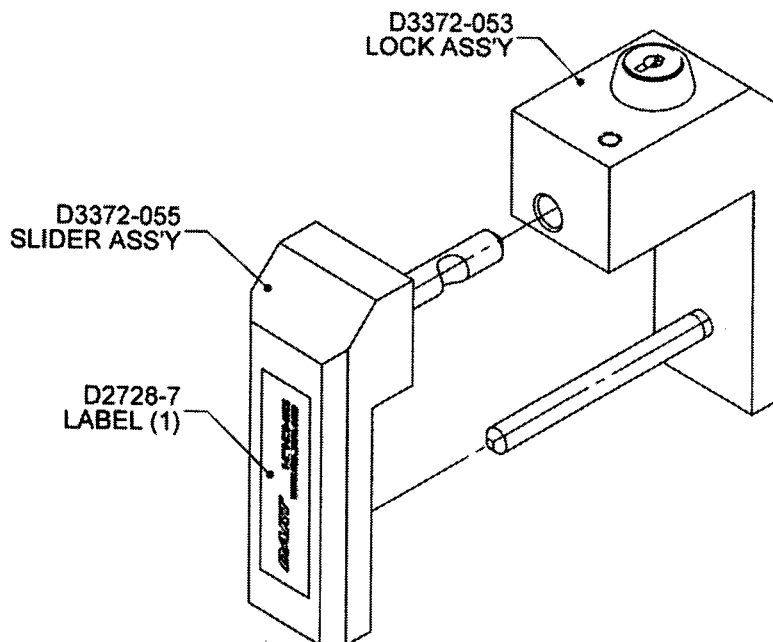
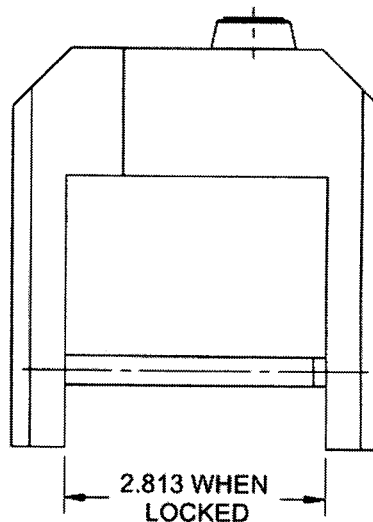
Rev.	Date	Change	Revised by	Approved
A.	05.04.26	New Issue	KJ/JLM	
B	09.05.04	Dimensions revised	KJ/DD	[Signature]



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CHECKED	APPROVED	DRAWING NO. D3372	REV. B SHEET 1 OF 8
DATE 05.02.23	TITLE COLLECTIVE LOCK		SCALE 1:2
A	05.01.10	NEW ISSUE	
B	05.02.23	REDESIGN FOR STANDARD 1/4 TURN LOCK, D3369-5 SUPERCEDES D3372-11 (OBSOLETE)	



**COLLECTIVE LOCK SHOWN
LOCKED WITH KEYS**



D3372-051 AS350 COLLECTIVE LOCK ASS'Y

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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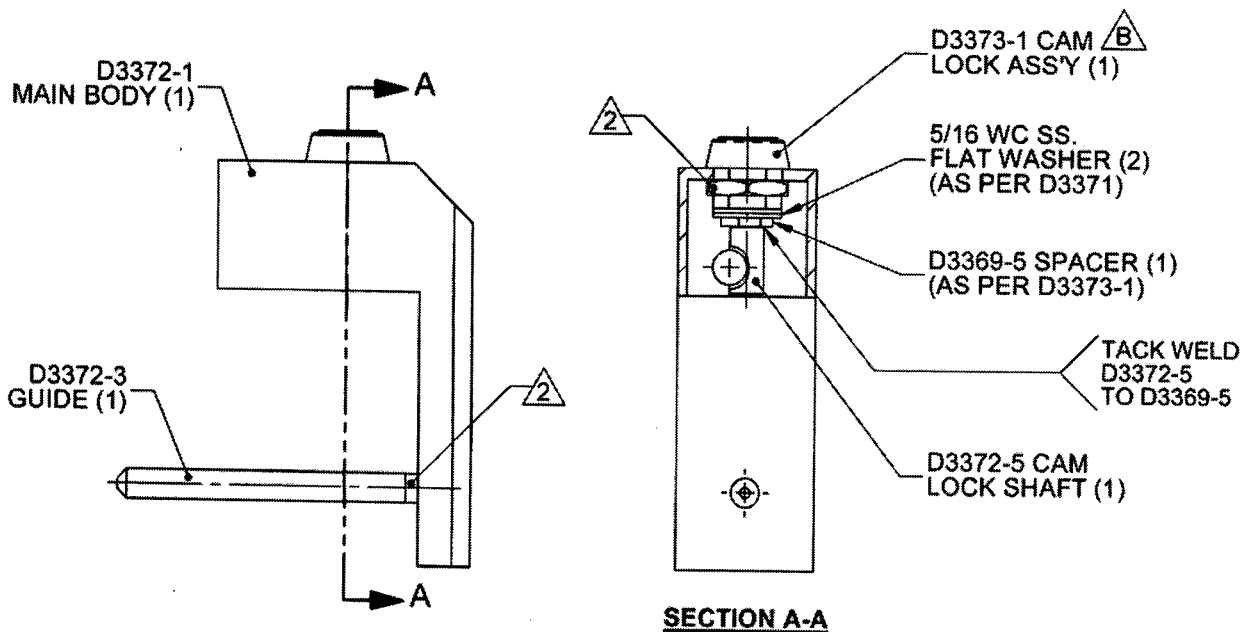
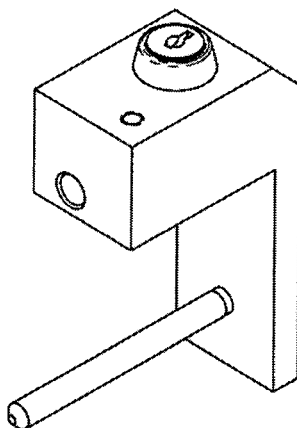
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

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D3372-053 LOCK ASS'Y

NOTES:

- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

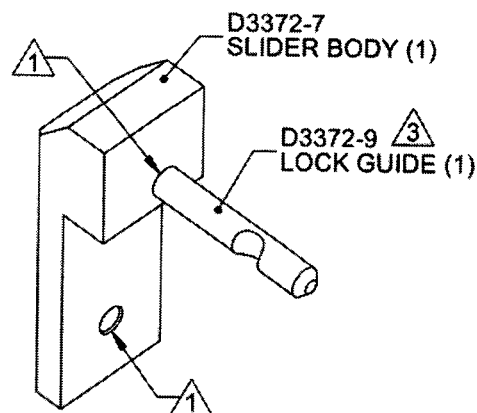
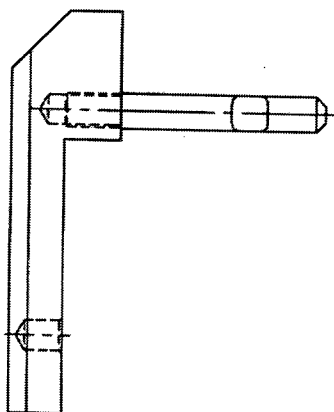
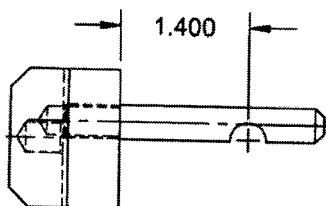
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

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D3372-055 SLIDER ASS'Y

NOTES:

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

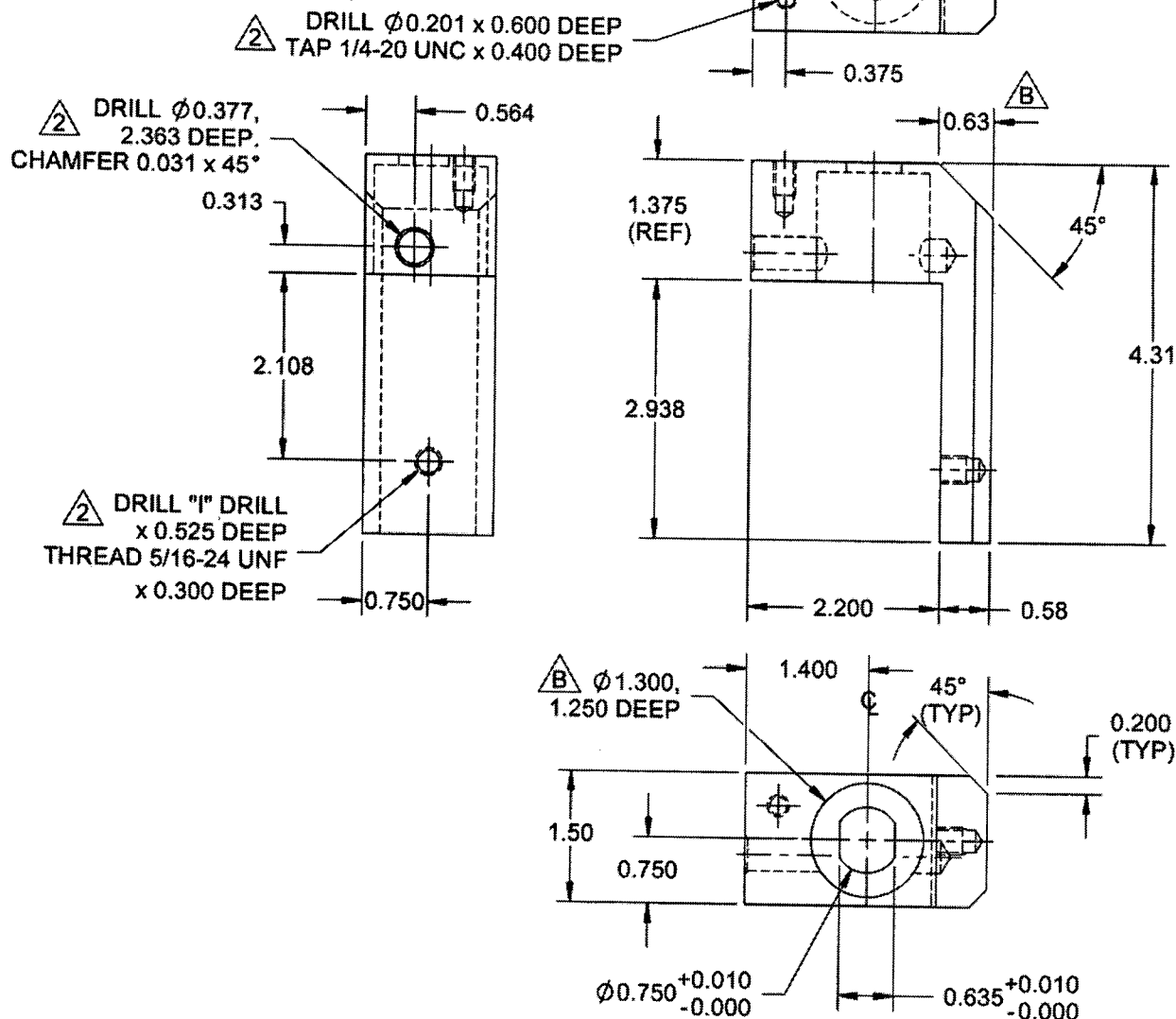
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DATE 05.02.23	TITLE COLLECTIVE LOCK	SHEET 4 OF 8	
		SCALE 1:2	

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D3372-1 MAIN BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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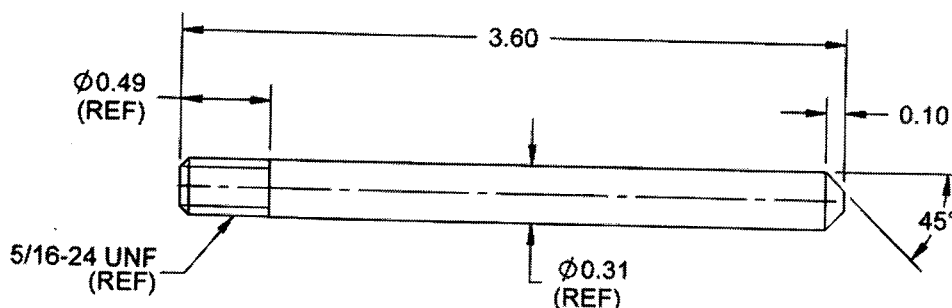
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SHEET 5 OF 8 SCALE 1:1

SPECIFICATION CONTROL DRAWING

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D3372-3 GUIDE

NOTES:

- 1) MATERIAL: AN5-42A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

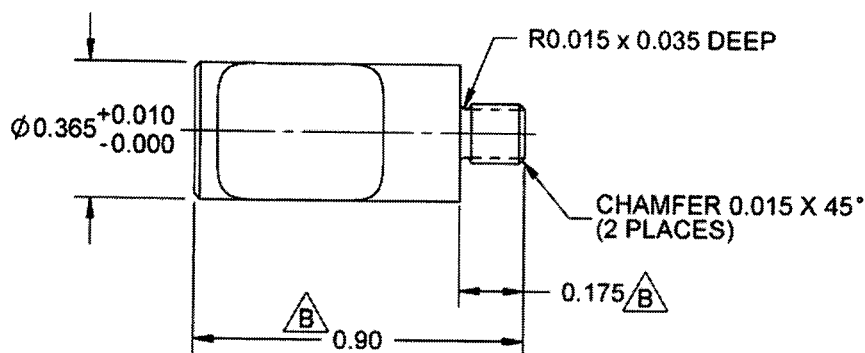
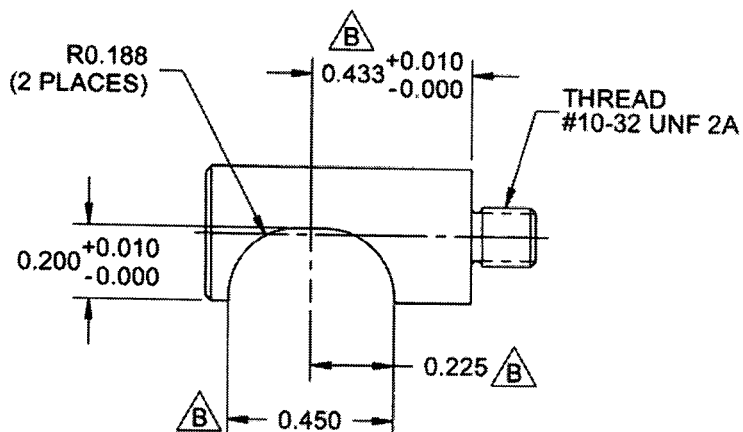
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SHEET 6 OF 8 SCALE 2:1

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D3372-5 CAM LOCK SHAFT

NOTES:

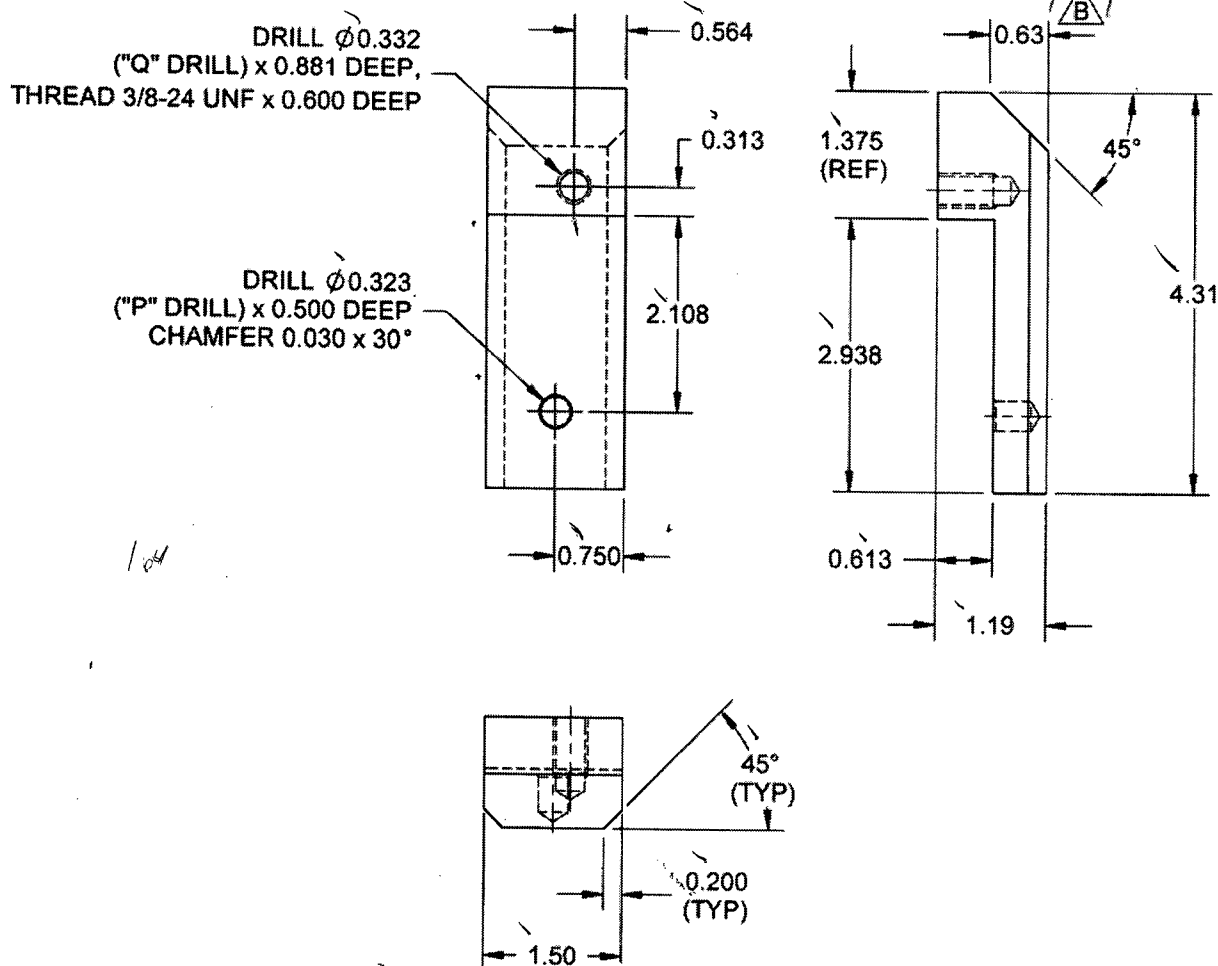
- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 05.02.23		TITLE COLLECTIVE LOCK	SHEET 7 OF 8 SCALE 1:2



D3372-7 SLIDER BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

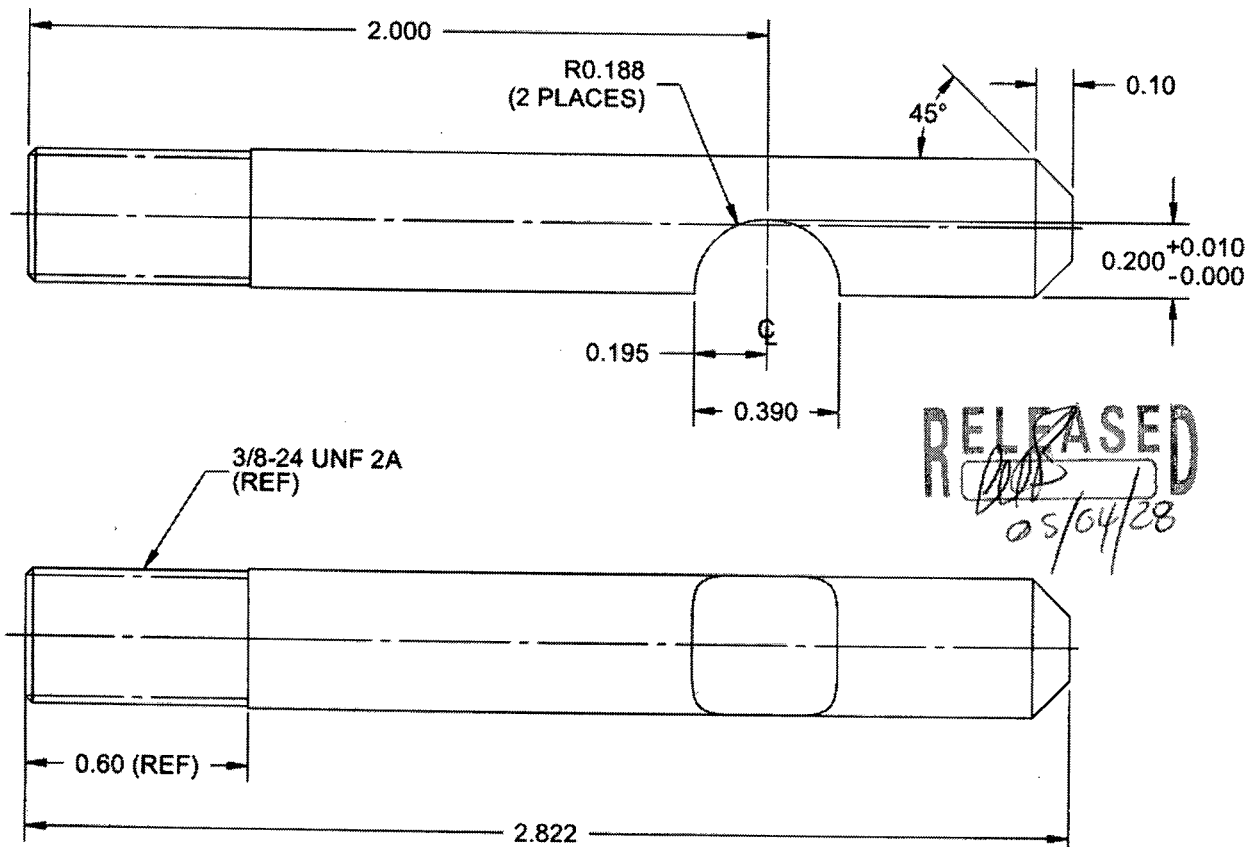
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DATE 05.02.23		TITLE COLLECTIVE LOCK SCALE 2:1	

SPECIFICATION CONTROL DRAWING



D3372-9 LOCK GUIDE

NOTES:

- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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